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D2521**Job Sheet 182808****Part No:** D2521**Job Qty:** 8 ea

DAG
21
9-89

Part Name: Individual Bearpaw**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 9/4/18**Job Tracking No:****Due Date:** 9/7/18**Created By:** Michelle Gagnon-Donovan**Type:** Stock**Description:****Note:** DWG REV J IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Container		OK 18/09/05
120	Waterjet	8 pcs	9/7/18	9/7/18	0.00	3.01	Waterjet 2 OMAX		OK 18/09/05
130	CNC Vertical Machining	8 pcs	9/7/18	9/7/18	0.39	13.89	HAAS 1		DSP 18/10/22
140	QC	8 pcs	9/7/18	9/7/18	0.00	0.00	QC2		DAG 18-10-22
150	QC	8 pcs	9/7/18	9/7/18	0.00	0.00	QC8		6 21 NOV 06 2018
160	Packaging	8 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3		9-89 Start
170	QC21-SA	8 Ea	9/7/18	9/7/18	0.00	0.00	QC21		21 NOV 06 2018

Part Op 120 - Cut Blank as per D2521 blank file

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	56 sf (7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	56	966	0

Part Specifications

Specifications could not be found.

Plex 9/4/18 8:50 AM Dart.Gagnon.Michelle



Container No: S108266



Part: D2521

Job No: 182808

Serial No/Batch: S108266

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 09/05/18

DART AEROSPACE LTD		Work Order: 182808
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	✓		G.P.	
B	0.90	0.96	0.930	✓		Uer	
C	0.27	0.330	0.308	✓		D.G.	
D	0.470	0.530	0.500	✓		Uer	
E	21.740	21.760	21.740	✓		"	
F	0.72	0.780	0.749	✓		"	
G	0.35	0.410	0.380	✓		"	
H	11.490	11.570	11.500	✓		"	
I	3.41	3.47	3.44	✓		"	
J	11.790	11.810	11.800	✓		"	
K	9.47	9.53	9.500	✓		"	
L	7.190	7.210	7.200	✓		"	
M	6.910	6.970	6.940	✓		"	
N	44.47	44.530	44.500	✓		Tape	
O	6.590	6.650	6.620	✓		Vern	
P	0.940	0.980	0.970	✓		"	
Q	18.97	19.03	19.00	✓		Tape	
R	0.350	0.410	0.380	✓		Vern	
S	0.740	0.780	0.753	✓		"	
T	0.240	0.280	0.260	✓		"	
U	0.370	0.410	0.380	✓		MM	
V	0.740	0.780	0.750	✓		Vern	
W	0.740	0.780	0.754	✓		"	

Measured by: DJP
Date: 18-10-22

Audited by: [Signature]
Date: 18/11/02

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	[Signature]

